

Work Order ID 126394

126394

Page 1

November-06-14 10:15:35 AM

Item ID: D119-675-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™, LH

Stop

NS2

Start Date: 11/06/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/21/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9647	A

100 Document Control 0.00
100
DC DOCUMENT CONTROL

Doc.Control -USB or Paperwork Memo 0.00
Photocopy bluefile & type labels per PPP D119-675-011 CHG005

110 Pick Kit 0.00

110
Packaging Memo 0.00
Packaging

120 QC4- 100% Inspect kits for completeness 0.00

120
QC Memo 0.00
Quality Control

2 FEB 05 2015

2 DAS 27 9-89 14/12/10

DAS 27 9-89

DAS 27 9-89

FEB 17 2015

Work Order ID 126394

126394

Page 2

November-06-14 10:15:35 AM

Item ID: D119-675-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™, LH
 Start Date: 11/06/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/21/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-675-011								
	Location: <u>021</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

2 FEB 13 2015 DAS 46 9.37

15/2/17 *[Signature]*
 15.2-17

Picklist Print

November-06-14 10:15:34 AM

Page 1

Work Order ID: 126394

126394

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/06/14

Required Date: 11/21/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
 IPP RevE change at rev.b as per ECN1107 DD verified by: IPP REV:F
 13.09.03 chg005 / DSI9647 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2274		Manufactured	No			110	Each	966.0000	8	16			
-------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

D2274
 Radius Block

DAS
 27
 9-89

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST006	954	
109534	6	
110264	2	
112466	2	
117869	305	
121589	273	
124363	366	

DAS
 27
 9-89
 14/12/01

D2617-3		Manufactured	No			110	Each	53.0000	4	8			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2617-3
 Bushing

DAS
 27
 9-89

Location	Loc Qty	Loc Code
FG	10	
27991	10	
ST008A	43	
106147	23	
107905	20	

DAS
 27
 9-89
 14/12/01

Picklist Print

November-06-14 10:15:34 AM

Page 2

Work Order ID: 126394

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step™, LH

126394

D119-675-011

Start Date: 11/06/14

Required Date: 11/21/14

Start Qty: 2.00

Required Qty: 2.00

D2617-5

Manufactured No

110 Each

36.0000

4 8

**

DAS
27
9-89
11/12/14

DAS
27
9-89
11/12/14

D2617-5

Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

31756

10

ST008A

26

125464

26

110 Each

41.0000

8 16

**

DAS
27
9-89
11/12/14

DAS
27
9-89
11/12/14

D2732-032

Manufactured No

D2732-032

Rubber Cushion - 32"

DAS
27
9-89

Location

Loc Qty

Loc Code

ST409

1

109546

1

ST410

40

117106

40

110 Each

15.0000

4 8

**

DAS
27
9-89
11/12/14

DAS
27
9-89
11/12/14

D3041-1

Manufactured No

D3041-1

Clamp

DAS
27
9-89

Location

Loc Qty

Loc Code

ST528

15

86255

15

110 Each

10.0000

2 4

**

DAS
27
9-89
11/12/14

DAS
27
9-89
11/12/14

D3041-3

Manufactured No

D3041-3

Clamp

DAS
27
9-89

Location

Loc Qty

Loc Code

ST520

10

84001

10

4

Picklist Print

November-06-14 10:15:34 AM

Page 3

Work Order ID: 126394

126394

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/06/14

Required Date: 11/21/14

Start Qty: 2.00

Required Qty: 2.00

D3041-5

Manufactured No

110 Each

27.0000

4 8

**

DAS
27
9-89

D3041-5

Clamp

Location

Loc Qty

Loc Code

ST528

27

106485

7

115538

20

Manufactured No

110 Each

13.0000

2 4

**

DAS
27
9-89

D3041-7

D3041-7

Clamp

Location

Loc Qty

Loc Code

ST528

13

106487

9

115539

4

Manufactured No

110 Each

0.0000

1 2

**

DAS
27
9-89

D3043-041

D3043-041

Step Weldment LH

AN4-15A

Purchased No

110 Each

388.0000

4 8

**

DAS
27
9-89

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

100

120449

100

ST325A

200

m130358

200

ST343

88

122141

4

m123525

6

m127817

11

m129732

67

DAS
27
9-89

DAS
27
9-89

Picklist Print

November-06-14 10:15:34 AM

Page 4

Work Order ID: 126394

126394

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/06/14

Required Date: 11/21/14

Start Qty: 2.00

Required Qty: 2.00

AN4-16A

Purchased

No

110

Each

120.0000

8

16

AN4-16A
Bolt

DAS
26
3-89

Location

Loc Qty

Loc Code

FG	5	
121541	5	
ST343	115	
M128324	19	
M128978	4	
M129590	42	
M130466	50	

DAS
27
8-89

14/12/01

NAS1149D0463J

Purchased

No

110

Each

8,267.000

12

24

NAS1149D0463J
WASHER

DAS
26
3-89

Location

Loc Qty

Loc Code

CA	459	
M129682	459	
ST260a	5000	
M130799	5000	
ST269	2808	
16941	8	
M126221	20	
M127813	6	
M127904	16	
M128591	44	
M128995	1121	
M129390	1593	

DAS
27
8-89

14/12/01

Picklist Print

November-06-14 10:15:35 AM

Page 5

Work Order ID: 126394

126394

Parent Item: D119-675-011

D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/06/14

Required Date: 11/21/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

4,626.000

12

24

MS21042L4

Locknut

DAS
27
9-89

14/11/01

DAS
13
49

DAS
06
9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST260a

2000

m130799

2000

ST305

2614

111827

2

126275

5

m126015

12

m126275

27

m127255

63

m127376

9

m127813

741

m128300

69

m128798

135

m129472

51

m129934

1500

2

DAS

25

9-99

REFERENCE ONLY

4.0 WEIGHT AND BALANCE:

Use the following Weight and Balance for D119-675-011/-012 @ CHG 005 or later.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.8 lb	-32.4 in	-382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, LH	5.4 kg	-1.28 m	-6.9 m-kg	3.08 m	16.6 m-kg
D119-675-012	11.8 lb	+32.4 in	+382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, RH	5.4 kg	+1.28 m	+6.9 m-kg	3.08 m	16.6 m-kg

5.0 PARTS LISTS:

QTY -011	Part Number	Description
X	DSI 9647-011	CLAMP REPLACEMENT KIT
4	D2732-032	RUBBER CUSHION
4	D3041-5	CLAMP
2	D3041-7	CLAMP
8	AN4-16A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	BOLT

Use the following Parts List for D119-675-011/-012 @ CHG 005 or later.

Qty. -011	Qty -012	Part Number	Description
X		D119-675-011	HELL-ACCESS-STEP™, LH
	X	D119-675-012	HELL-ACCESS-STEP™, RH
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
4	4	D2617-5	BUSHING
8	8	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3041-5	CLAMP
2	2	D3041-7	CLAMP
1	1	D3043-041	STEP WELDMENT LH
1	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
8	8	AN4-16A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9647	SHEET 3 OF 6
APPROVED	160	TITLE	SCALE
DE APPR.	111	CLAMP REPLACEMENT	NTS
DATE	13.04.04	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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126394

Page 1

November-06-14 10:15:35 AM

Item ID: D119-675-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™, LH

Start Date: 11/06/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/21/14 Req'd Qty: 2.00

2

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9647

A

100

Document Control

0.00

DAG
27
3-83

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-675-011 CHG005

MCS

15-02-05

2

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAG
27
3-83

14/12/10

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control